

# Work Order ID 83959

**\*83959\***

Page 1

April-30-12 8:43:29 AM

Item ID: D4092-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Maintenance Step Assembly

Start Date: 30/04/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: *ML5*

Date: *12/04/30* Tooling:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4092

B

100 Pick Kit

0.00

**\*100\***

Packaging

Memo

0.00

Packaging

*2x* *Ø* *ES 12/04/27*

110

0.00

**\*110\***

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

*2x* *Ø* *ES 12/04/27*

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*ES 12/04/30*

*(12)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83959

\*83959\*

Page 2

April-30-12 8:43:29 AM

Item ID: D4092-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 30/04/2012 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location <i>270</i>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00				<i>2x</i>			<i>12/14/30</i>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*12/14/30*  
*NUC*  
*12-04-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

April-30-12 8:43:33 AM

Page 1

Work Order ID: 83959

\*83959\*

Parent Item: D4092-041

\*D4092-041\*

Parent Item Name: Maintenance Step Assembly

Start Date: 30/04/2012

Required Date: 04/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD IPP  
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No			100	Each	10.0000	2	4			
*D4092-1*									**				
Maintenance Step													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		9							
				77852		1							
				80564		2							
				81734		2							
				82765		4							
				ST241A		1							
				74303		1							
D4093-1		Manufactured	No			100	Each	3.0000	1	2			
*D4093-1*									**				
Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST195		3							
				82766		3							
D4093-3		Manufactured	No			100	Each	17.0000	1	2			
*D4093-3*									**				
Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST139E		8							
				83639		8							
				ST195		9							
				77850		1							
				80084		1							
				82767		7							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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April-30-12 8:43:33 AM

Page 2

Work Order ID: 83959

\*83959\*

Parent Item: D4092-041

\*D4092-041\*

Parent Item Name: Maintenance Step Assembly

Start Date: 30/04/2012

Required Date: 04/05/2012

Start Qty: 2.00

Required Qty: 2.00

D4093-5 Manufactured No

100 Each 6.0000 2 4

\*D4093-5\*

Bracket

\*\*

EP 12/04/27

Location

Loc Qty

Loc Code

ST124

6

80085

2

82764

4

4

MS24694-S54

Purchased No

100 Each 120.0000 2 4

\*MS24694-S54\*

Screw

\*\*

EP 12/04/27

Location

Loc Qty

Loc Code

ST289A

120

120142

4

120361

2

121166

64

121524

50

4

MS24694-S55

Purchased No

100 Each 106.0000 8 16

\*MS24694-S55\*

Screw

\*\*

EP 12/04/27

Location

Loc Qty

Loc Code

ST289A

106

119307

33

120910

71

121444

2

16

MS24694-S56

Purchased No

100 Each 108.0000 2 4

\*MS24694-S56\*

SCREW

\*\*

EP 12/04/27

Location

Loc Qty

Loc Code

ST289A

108

120142

12

121340

96

4

April-30-12 8:43:33 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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April-30-12 8:43:33 AM

Page 3

Work Order ID: 83959

\*83959\*

Parent Item: D4092-041

\*D4092-041\*

Parent Item Name: Maintenance Step Assembly

Start Date: 30/04/2012

Required Date: 04/05/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

100

Each

2,508.000

12

24

\*NAS1149D0332.J\*

\*\*

Washer

## Location

## Loc Qty

## Loc Code

ST298

2508

105793

12

110985

4

117087

89

119042

38

119717

541

120644

193

121011

1631

24

MS21042L3

Purchased

No

100

Each

3,237.000

12

24

\*MS21042L3\*

\*\*

Nut

## Location

## Loc Qty

## Loc Code

ST300

3237

117441

16

117885

32

118451

5

118927

3

119017

1182

119075

158

121349

841

121444

1000

24

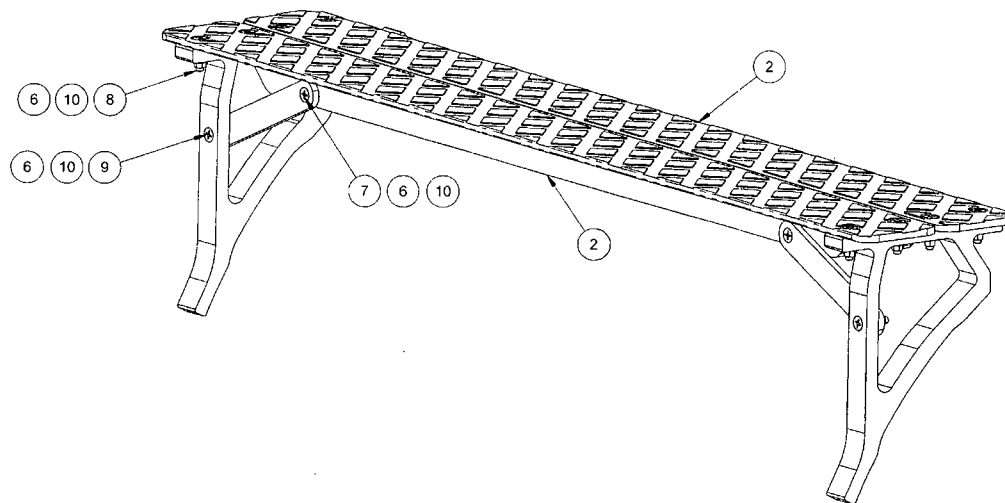
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4092-041 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83959 MLCJ

12/04/30

RELEASED  
2011-09-22  
MD

B	REDRAWN: LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 1 OF 6
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

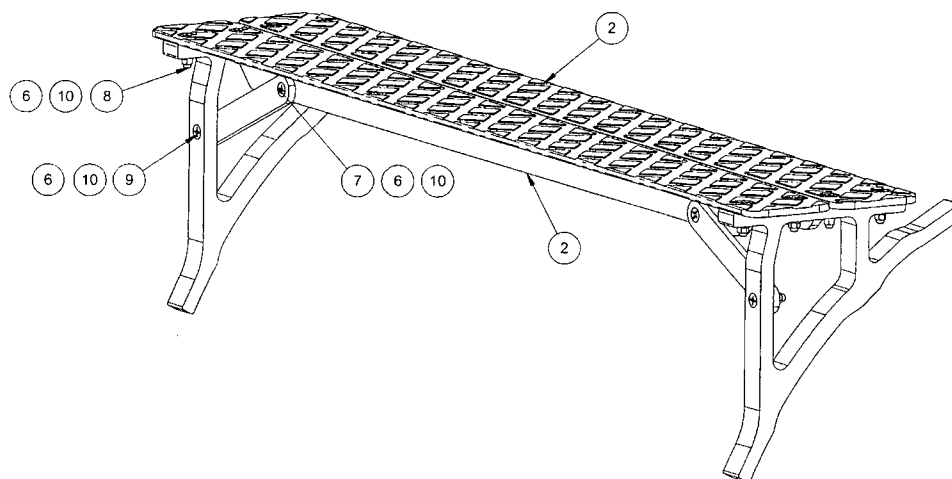
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



**D4092-042 MAINTENANCE STEP ASSEMBLY**



**RELEASED**  
2011-09-20  
JW

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	8/1	D4092	SHEET 2 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
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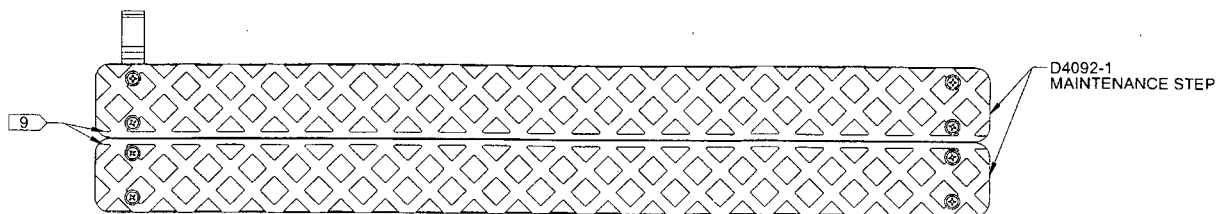
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

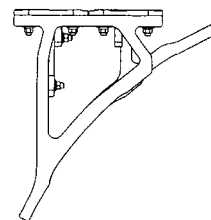
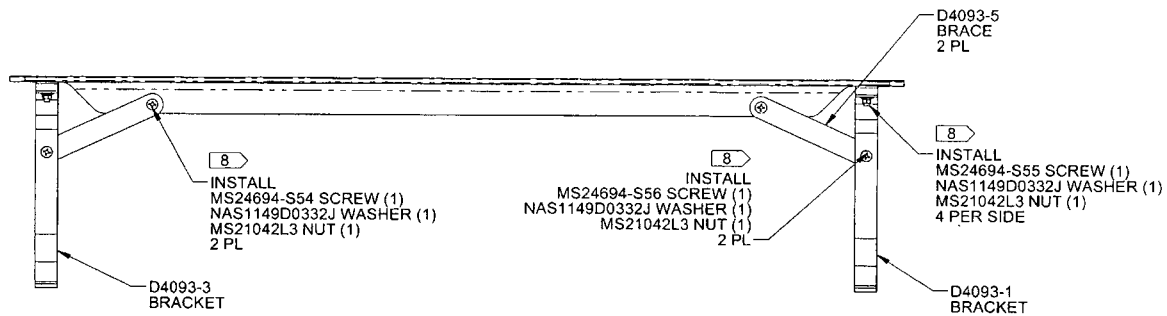
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



83959



# **D4092-041 MAINTENANCE STEP ASSEMBLY**

**RELEASED**  
2011-09-22

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER QSI 044 6.1
  - 7) WEIGHT: 5.37 lbs
  - 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
  - 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 3 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

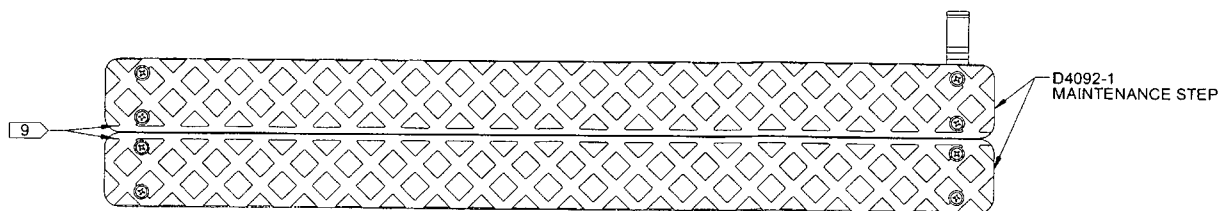
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

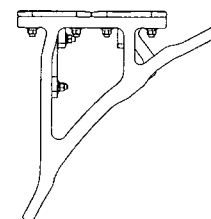
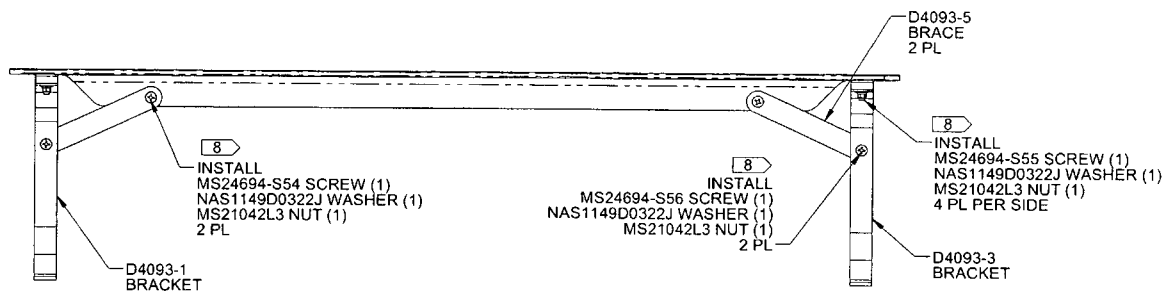
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





83959



RELEASED  
2011-09-22

# **D4092-042 MAINTENANCE STEP ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 4 OF 6
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DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

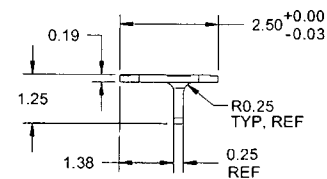
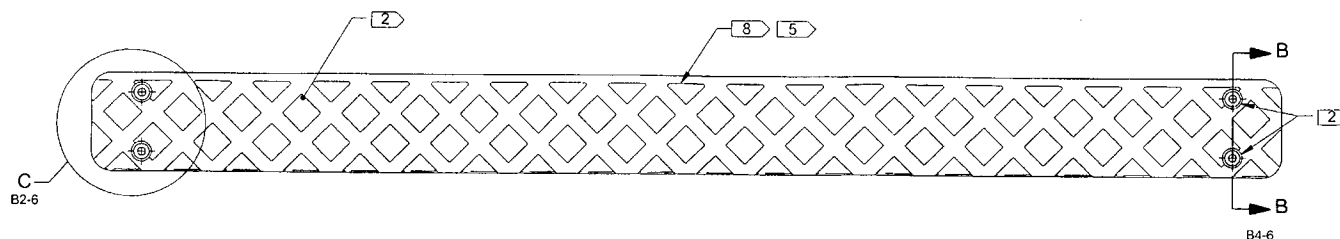
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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83959



**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JWW

**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4092</b>	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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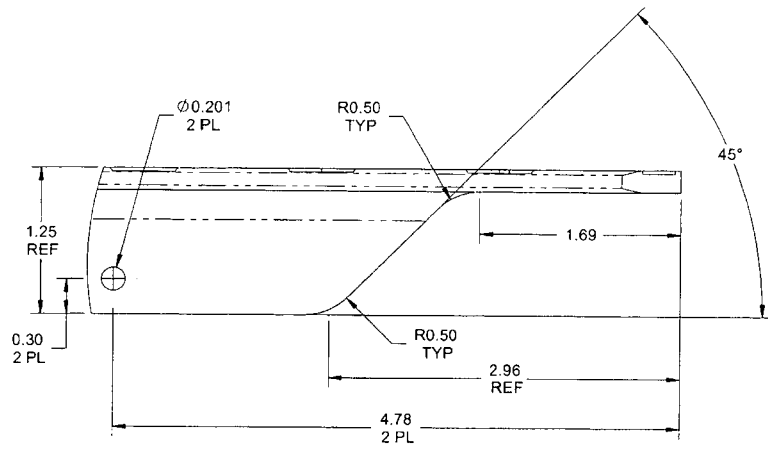
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

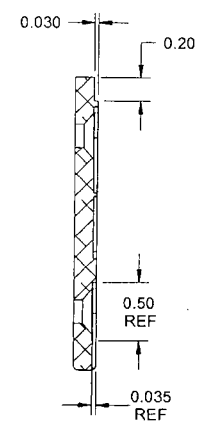
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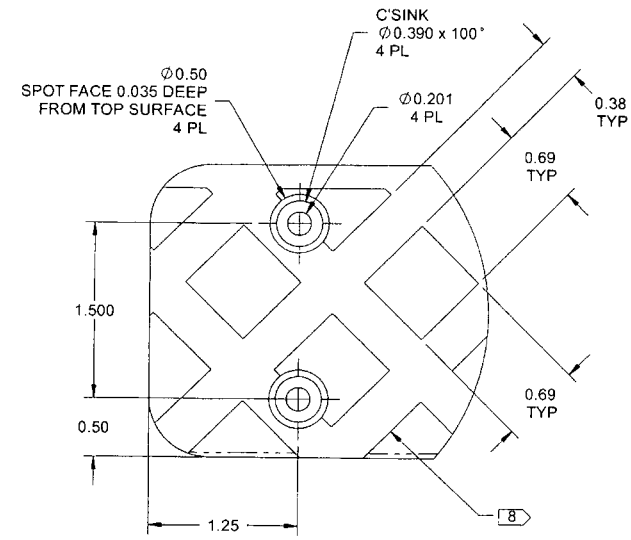
83959



**DETAIL A** B3-5  
SCALE 3X, TYP



**SECTION B-B** C3-5  
SCALE 3X, TYP



**DETAIL C** C8-5  
SCALE 3X, TYP

**RELEASED**  
2011-09-22  
JW

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D4092	SHEET 6 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	<b>MAINTENANCE STEP ASSY</b>	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries